

Date: Tuesday, 07/04/2009 10:22:34 AM
 User: Julie Dawson

Process Sheet

SPLIT-1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GHW LUG
Job Number	: 46986 -1	Part Number	: D34041
Estimate Number	: 11217	Drawing Number	: D3404 REV C
P.O. Number	:	Project Number	: N/A
This Issue	: 07/04/2009 S.O. No. :	Drawing Revision	: C
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : MACHINED PARTS	Due Date	: 24/04/2009
Previous Run	: 46697	Qty:	40 Um: Each
Written By	:		
Checked & Approved By	: <u>JLD 09.04.07</u>		
Comment	: Est Rev:A 05.09.01 New issue KJ/JLM Est rev B 09.01.28 new geometry rev.C EC verified by:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304B0750X2500	304 BAR .750 X 2.50
-----	----------------	---------------------



Comment: Qty.: 0.2406 f(s)/Unit Total : 9.6222 f(s)
 Material: AISI 304/316 SS Bar 2.50" x 0.75" thick
 (M304B0.750x02.500)
 Identify for D3404-1
 Batch: M110727

M105802 X 19

mk 09/04/16

42

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blank: 2.750" long

mk 09/04/16

42

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA555 and Dwg D3404
 Dwg Rev: C Folio Rev: C

2-Deburr

SP 09/04/20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SP 09/04/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:22:34 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW LUG

Job Number: 46986

Part Number: D34041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

3L 09/04/20

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W/A Larague's Booth

KL 9-4-20

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

209/04/20

Job Completion



U 09-04-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

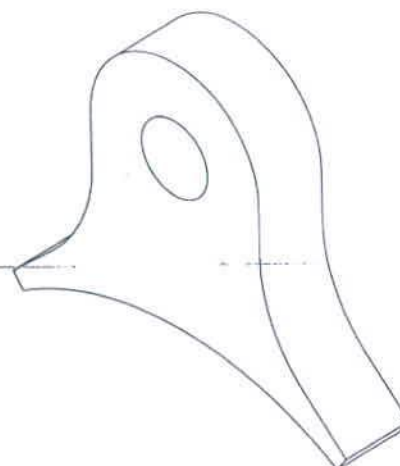
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 40980



D3404-1 GHW LUG

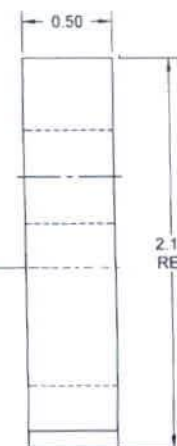
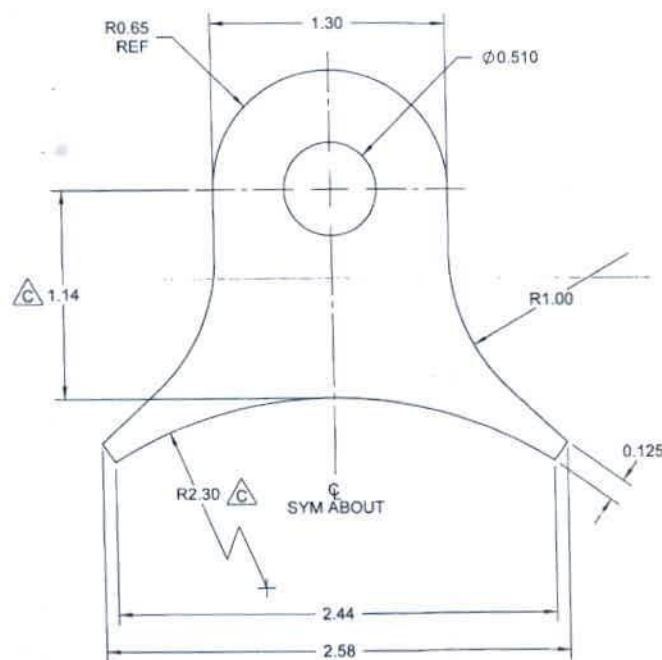
RELEASED
06/12/15 NW

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

C	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. B6-2, 2.30 RAD WAS 2.13. C7-2 1.14 DIM WAS 1.20.	AJS	08.12.02
B	UPDATE M-SPEC	PH	05.06.14
A	NEW ISSUE	PH	05.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3404	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	GHW LUG	NTS
DATE	08.12.02	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHDRAWN
WORK IN PROGRESS
NO 4098.0



RELEASED
08/12/02

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3404	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG	NTS
DATE	08.12.02	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

